

ABSTRACT

A conveyance system, wherein dividable horizontal conveyance units (16a, 16b) are connected to each other through joint plates (120) and a support post (22) and rails (28) of the horizontal conveyance units (16a, 16b) are connected to each other without any step and clearance. A joint conveyance carriage assembly (12) is conveyed by a force applied thereto from annular chains (30) of the horizontal conveyance units (16a) and (16b) through chain presser plates (242). When the rearmost one of the chain presser plates (242) leaves the annular chain (30) of the horizontal conveyance unit (16a), the chain presser plate (242) of the headmost first conveyance carriage (200) reaches the annular chain (30) of the horizontal conveyance unit (16b) and the joint conveyance carriage assembly (12) is continuously conveyed.